

Work Order ID 63157

Thursday, October 21, 2010 3:55:33 PM



Page 1

Item ID: D412-704-041

Accept



Setup Start

Stop



Revision ID:

Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010 **Start Qty:** 1.00



Cust Item ID:

Required Date: 10/28/2010 **Req'd Qty:** 1.00



Customer:

Reference:

Approvals: **Process Plan:**

Date: 16-10-22 Tooling:

Date:

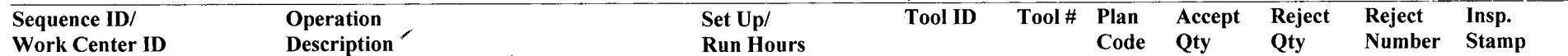
Run Star



Date: _____ **SPC (Y/N)**

Date: _____

Stop



Draw Nbr	Revision Nbr	
D412-704-041	Rev A	
100		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble pedal as per Dwg D412-704-041 Tighten & Torque Bolts as per Dwg D412-704-041	
110	QC5- Inspect part completeness to step on W/O	0.00
	Memo	
QC		8/10/2024
Quality Control		
120	Pick Kit	0.00
	Memo	
Packaging		0.00
Packaging		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start



Revision ID:

Item Name: Pedal Assembly (205/212/214/412)

Stop



Start Date: 10/21/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Sokube

140



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

191

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Comments: IPP Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF
IPP Rev:C 06.03.08 Re-format EC
IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
IPP Rev:E 07.05.02 Reformat EC
IPP Rev:F 08-10-08 as per revB DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Thursday, October 21, 2010 3:55:37 PM

Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN4-12A

Purchased

No

100

Each

306.0000

2

2

Bolt

Location	Loc Qty	Loc Code
ST357	306	
112314	106	
115371	40	
115422	160	

EBS 10/10/25

2

AN4-13A

Purchased

No

100

Each

502.0000

1

1

Bolt

Location	Loc Qty	Loc Code
ST357	300	
115936	300	
ST358	202	
115159	202	

EBS 10/10/25

1

AN960JD10

NAS1149D0363J Purchased

No

40 1115622 (5x)

Washer

100 Each 8.0000

5

5

EBS 10/10/25

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

100 Each 24.0000

11

11

EBS 10/10/25

Location	Loc Qty	Loc Code
ST300	24	
113288	24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, October 21, 2010 3:55:37 PM

Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L



NAS1149D0416J Purchased

No

100

Each

219.0000

3

*EBS 10/10/15*

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST346	219	
106785	2	
110153	217	

D3204-041



Manufactured

No

100

Each

4.0000

1

*EBS 10/10/15*

Release Pedal Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST197	4	
60509	4	

D3205-1



Manufactured

No

100

Each

4.0000

1

*EBS 10/10/15*

Pedal Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST197	4	
55731	4	

D3205-3



Manufactured

No

100

Each

6.0000

1

*EBS 10/10/15*

Back Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST197	6	
47491	6	

D3206-1



Manufactured

No

100

Each

9.0000

1

*EBS 10/10/15*

Pedal Arm

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST197	9	
55732	9	

*EBS 10/10/15*

Thursday, October 21, 2010 3:55:37 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

D3209-041



Manufactured

No

100

Each

5.0000

1

1

EJ310/10/25

Bracket Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST045	1	
58265	1	
ST202	4	
60295	4	

MS21042L3



Purchased

No

100

Each

2,338.000

1

EJ310/10/25

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2338	
114523	49	
114784	1289	
115835	1000	

MS21042L4



Purchased

No

100

Each

3,253.000

5

EJ310/10/25

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3253	
113422	68	
114523	8	
114718	16	
114784	32	
115108	129	
115589	1900	
115621	1100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS24694-S102



Purchased

No

100

Each

54.0000

1

1

Screw

EP 10/10/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST288	50	
114382	50	
ST289A	4	
113644	4	

MS9519-10



Purchased

No

100

Each

36.0000

1

1

Bolt

EP 10/10/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	36	
100290	36	

AN3-6A



Purchased

No

120

Each

208.0000

2

1

Bolt

10/10/25 SF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	208	
113359	8	
114941	200	

AN960JD10L



NAS1149D0332J Purchased

No

120

Each

0.0000

4

2

Washer

M114962 10/10/25 SF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 63157



Parent Item: D412-704-041



Parent Item Name: Pedal Assembly (205/212/214/412)

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

120

Each

2,338.000

1

2



Nut



10/10/2010

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2338	
114523	49	
<u>114784</u>	1289	<u>2</u>
115835	1000	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

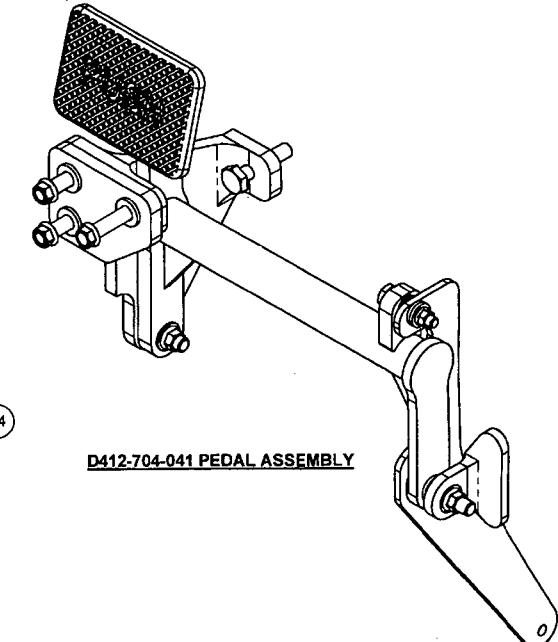
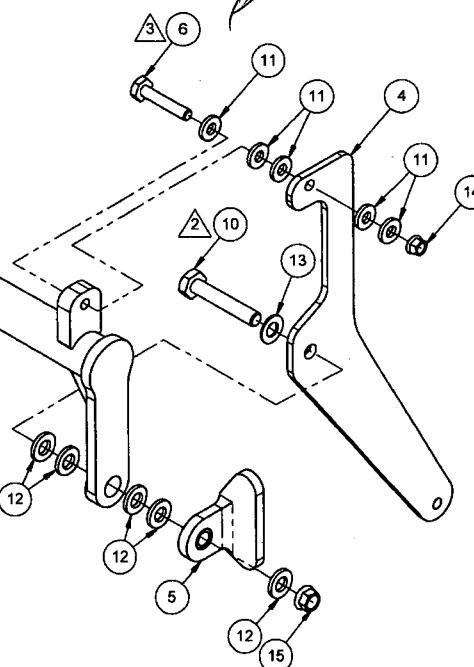
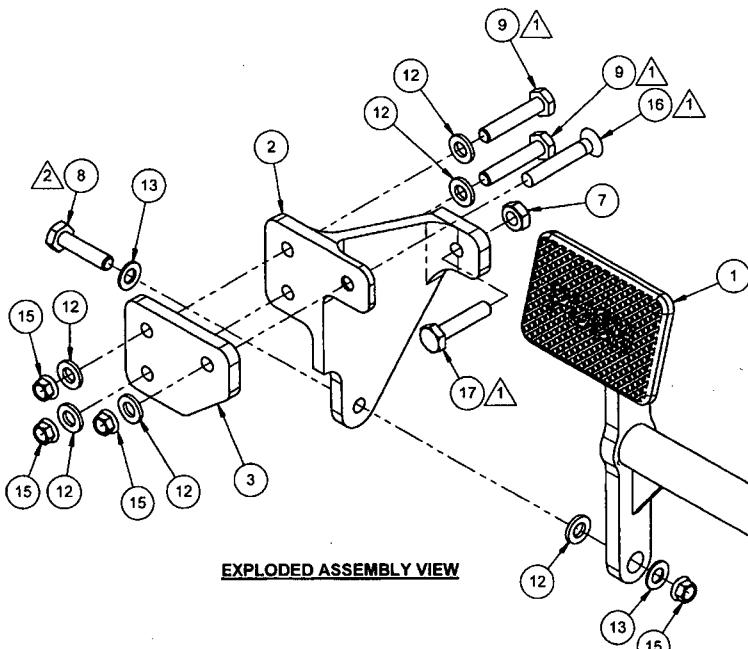
4

3

2

1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63157
0701-10-22



PARTS LIST:

ITEM	QTY	P/N	DESCRIPTION
-	X	D412-704-041	PEDAL ASSEMBLY
1	1	D3204-041	PEDAL WELDMENT
2	1	D3205-1	PEDAL BRACKET
3	1	D3205-3	BACK PLATE
4	1	D3206-1	PEDAL ARM
5	1	D3209-041	BRACKET ASSEMBLY
6	1	AN3-10A	BOLT
7	1	AN315-4R	NUT
8	1	AN4-10A	BOLT
9	2	AN4-12A	BOLT
10	1	AN4-13A	BOLT
11	5	AN960JD10	WASHER
12	11	AN960JD416	WASHER
13	3	AN960JD416L	WASHER
14	1	MS21042L3	NUT (OR MS21042-3)
15	5	MS21042L4	NUT (OR MS21042-4)
16	1	MS24694-S102	SCREW
17	1	MS9519-10	BOLT
N/A*	2	AN3-6A	BOLT
N/A*	4	AN960JD10L	WASHER
N/A*	2	MS21042L3	NUT (OR MS21042-3)

* SHIPPED LOOSE WITH -041 KIT (NOT PRE-ASSEMBLED AT DART)

NOTES:

- 1) INSTALL IDENTIFIED FASTENERS LOOSE (HAND TIGHTEN ONLY).
- 2) TIGHTEN IDENTIFIED FASTENERS UNTIL SNUG. ENSURE THAT PARTS CAN STILL ROTATE.
- 3) TORQUE IDENTIFIED FASTENERS TO 15-25 in-lbs (1.7-2.8 N-m).

A	07.01.23	NEW ISSUE	DESCRIPTION
REV	DATE	DESIGN	DRAWN BY
C.B	07.01.23	C.B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECDED	APPROVED		DRAWING NO. D412-704-041
LE	✓		REV. A SHEET 1 OF 1
DATE	TITLE		SCALE
07.01.23	PEDAL ASSEMBLY		1:2

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RELEASED

07.01.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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